

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008255**Date Inspected:** 03-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Jin Dong Liang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY#10

Magnetic Particle Inspection

This QA Inspector performed Magnetic particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (MT) report for this date. The members are identified as the Skin E and C of Lift 4, North tower the welds Designation are as follows.

NSD1-FESA4-3A/F-6A

NSD1-FCSA-1A/C-59A, 64A

This QA Inspector randomly observed the following work in progress

BAY#10

FCAW welding process of weld joint 35 located on PCMK NSD1-FDSA3-1C/C. Welder is identified as 201825 ZPMC QC is identified as Wei song Shi. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SAW welding process of weld joint 124B located on PCMK NSD1-A166E/J. Welder is identified as 050295 ZPMC QC is identified as Jin Dong Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221C-U2B-S-2

FCAW welding process of weld joint 27 located on PCMK NSD1-FDSA3-1C/C. Welder is identified as 050041 ZPMC QC is identified as Wei song Shi. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F

SAW welding process of weld joint 2B located on PCMK NSD1-A112B/H. Welder is identified as 040489 ZPMC QC is identified as Jin Dong Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221C-U2B-S-2

SAW welding process of weld joint 7B located on PCMK NSD1-FASA4-1A/E. Welder is identified as 050295 ZPMC QC is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221- B-U3C-S-3

SAW welding process of weld joint 73B located on PCMK SSD1-FASA4-1E/E. Welder is identified as 0207746 ZPMC QC is identified as Jin Yang Ming Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3-S-2

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
